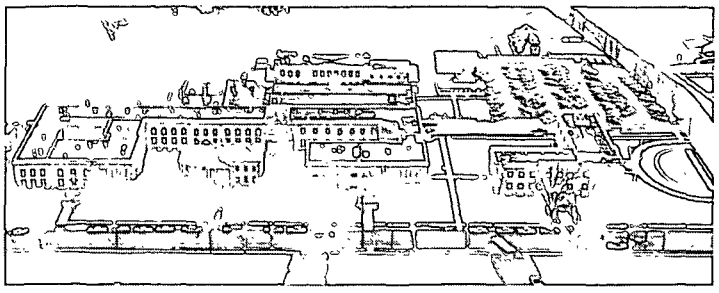

THE INSTITUTE OF PAPER CHEMISTRY, APPLETON, WISCONSIN

CONTINUOUS BASE-LINE STUDY (MODIFIED)
(MILL CORRUGATING MEDIUM DATA FOR OCTOBER, NOVEMBER, DECEMBER, 1985)

Project 2694-2

Report Sixty-Two

A Progress Report

to

FOURDRINIER KRAFT BOARD GROUP

OF THE

AMERICAN PAPER INSTITUTE

March 1, 1986

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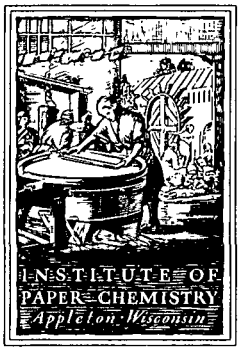

THE INSTITUTE OF PAPER CHEMISTRY
Post Office Box 1039
Appleton, Wisconsin 54912
Phone: 414/734-9251
Telex: 469289

March 1, 1986

Project 2694-2

Dear Sir:

We are enclosing a copy of the following report to the Fourdrinier Kraft Board Group of the American Paper Institute:

Report Sixty-Two, Project 2694-2, a progress report entitled, "Continuous Baseline Study (Modified) of Mill Corrugating Medium Data for October, November, December, 1985" dated March 1, 1986

The code identities for paper machines in your company from which data were submitted for evaluation are given on the inside of the front cover of this report.

The FKBG Technical Committee has requested that future reports for this project be issued semi-annually instead of quarterly. Therefore the next report will be issued September 1, 1986.

Sincerely,

Roger H. Van Eperen

Roger H. Van Eperen
Research Associate
Paper Materials Division

RHV/les
Enclosure

GEORGIA-PACIFIC CORP.
Your machine is identified
in this report by the
following code.

Toledo Machine #2 E2

BASE-LINE
4th QUARTER, 1985

THE INSTITUTE OF PAPER CHEMISTRY

Appleton, Wisconsin

CONTINUOUS BASE-LINE STUDY (MODIFIED)
(MILL CORRUGATING MEDIUM DATA FOR OCTOBER, NOVEMBER, DECEMBER, 1985)

Project 2694-2

Report Sixty-Two

A Progress Report

to

FOURDRINIER KRAFT BOARD GROUP

OF THE

AMERICAN PAPER INSTITUTE

March 1, 1986

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THE INSTITUTE OF PAPER CHEMISTRY

Appleton, Wisconsin

CONTINUOUS BASE-LINE STUDY (MODIFIED)
(MILL CORRUGATING MEDIUM DATA FOR OCTOBER, NOVEMBER, DECEMBER, 1985)

SUMMARY OF 26-LB CORRUGATING MEDIUM DATA
(SEP-DEC, 1985)

Test		SEP		OCT		NOV		DEC	
		Total	Recycled	Total	Recycled	Total	Recycled	Total	Recycled
Moisture content, %	Max.	9.6	7.2	9.7	7.1	9.5	7.0	9.7	7.0
	Min.	4.4	4.4	4.4	4.4	4.3	4.3	4.4	4.4
	Ave.	6.7(33)	5.8(13)	6.7(33)	5.8(12)	6.6(32)	5.8(12)	6.6(32)	5.8(12)
Adj. basis weight, lb/M sq ft	Max.	27.0	27.0	27.0	27.0	27.2	27.2	27.0	27.0
	Min.	25.2	26.2	25.2	26.1	25.3	26.0	25.3	26.1
	Ave.	26.4(33)	26.6(13)	26.4(33)	26.6(12)	26.4(32)	26.6(12)	26.4(32)	26.6(12)
Caliper, mils	Max.	10.6	10.6	10.8	10.8	10.7	10.7	10.9	10.9
	Min.	7.8	7.8	7.8	7.8	7.7	7.7	7.7	7.7
	Ave.	9.5(26)	9.6(12)	9.5(27)	9.4(12)	9.5(26)	9.4(12)	9.5(26)	9.3(12)
Concora, lb	Max.	69.8	69.8	69.0	69.0	69.4	69.4	69.3	69.3
	Min.	53.7	53.7	55.8	55.8	55.4	55.4	56.8	56.8
	Ave.	61.0(33)	60.3(13)	60.7(33)	60.4(12)	60.9(32)	60.7(12)	60.8(32)	60.9(12)
CD Ring Crushelb	Max.	43.0	41.0	44.0	44.0	42.0	39.0	42.0	38.0
	Min.	24.0	26.5	24.0	26.0	23.7	23.7	24.0	24.6
	Ave.	32.2(23)	32.0(7)	31.8(23)	31.7(7)	31.6(23)	31.2(7)	31.4(23)	31.1(7)

Max. and Min. values are current machine averages.
Ave. value is current F.M.S.S. average, number of machines is indicated in parentheses.

INTRODUCTION

The continuous base-line study (modified) is a compilation of monthly averages of mill test data obtained routinely on 26-lb corrugating medium manufactured in the member mills of F.K.B.G. Mill data are included for moisture content, basis weight, caliper, Concora, and C.D. Ring Crush made on the production of individual machines which produced at least 500 tons of this grade weight during a given month.

PRESENTATION OF DATA

For the 26-lb grade weight of corrugating medium referred to earlier, data on conditioning and testing environments, mill test averages for moisture content, adjusted basis weight, caliper, Concora, and C.D. Ring Crush results are compiled in the following tables.

Table Number	Description
I-II-III-IV	Mill Test Averages on 26-Lb Corrugating Medium
V	Data on Conditioning and Testing Environments

The procedure used in calculating cumulative machine averages, machine factors, machine indexes, and F.K.B.G. indexes are described in the Appendix.

It should be explained that the number of machines for which data are compiled in each table for a specified month varies for these reasons: a machine must have (a) produced at least 500 tons of 26-lb corrugating medium during the specified month, or (b) produced 500 tons of 26-lb corrugating medium during <u>any one or more</u> of the 12 months prior to the specified month (so that a cumulative average is available), to be included in a given table.

TABLE I

AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM

OCTOBER, 1965

	MOISTURE CONTENT, PERCENT				ADJ. BASIS WT., #A LB./M SQ. FT.				CALIPER, PT.				CONCORA TEST LB.			
	MACHINE DATA				MACHINE DATA				MACHINE DATA				MACHINE DATA			
CODE #E	CUR. AV.	CUM. AV.	FACT. #B	IND. #C	CUR. AV.	CUM. AV.	FACT. #B	IND. #C	CUR. AV.	CUM. AV.	FACT. #B	IND. #C	CUR. AV.	CUM. AV.	FACT. #B	IND. #C
A1	6.1	5.9	103.4	92.4	26.7	26.7	100.0	101.1					59.0	58.8	100.3	96.6
B1		6.0				26.1				7.9				76.0		
F1	7.3	7.7	94.8	110.6	26.0	26.0	100.0	98.5					59.0	60.2	98.0	96.6
J1	7.3	6.9	105.8	110.6	26.2	26.3	99.6	99.2	10.0	9.6	104.2	104.2	60.0	60.2	99.7	98.2
K1	7.6	7.4	94.6	106.1	26.1	26.3	99.2	98.9					61.0	61.2	99.7	99.8
L1	6.5	6.5	100.0	98.5	26.3	26.3	100.0	99.6	9.6	9.8	98.0	100.0	60.7	62.2	97.6	99.3
O1	7.6	7.4	102.7	115.2	26.6	26.5	100.4	100.8	10.5	10.2	102.9	109.4	58.0	58.1	99.8	94.9
S1(A)		7.3				26.3								61.7		
U1	9.0	8.7	103.4	136.4	25.7	25.8	99.6	97.3	10.6	10.6	100.0	110.4	60.6	61.4	98.7	99.2
A2	6.9	6.8	101.5	104.5	26.2	26.3	99.6	99.2					62.0	61.7	100.5	101.5
E2(A)	7.1	7.2	98.6	107.6	26.2	26.2	100.0	99.2	10.8	11.2	96.4	112.5	62.3	62.5	99.7	102.0
H2	7.2	7.0	102.8	109.8	26.0	26.2	99.2	98.5					59.0	60.5	97.5	96.6
I2	9.7	9.5	102.1	147.0	25.2	25.2	100.0	95.4	9.8	10.0	98.0	102.1	63.3	64.8	97.7	103.6
J2(A)	5.5	5.3	103.8	83.3	26.4	26.7	98.9	100.8	7.8	7.8	100.0	81.2	59.9	59.5	100.7	98.0
K2(A)	5.8	5.8	100.0	87.9	26.8	26.6	100.8	101.5	10.5	10.4	101.0	109.4	60.9	60.9	100.0	99.7
L2(A)	7.0	7.0	100.0	106.1	26.3	26.4	99.6	99.6	9.1	9.3	97.8	94.8	69.0	69.4	99.4	112.9
N2	6.8	6.6	103.0	103.0	26.6	26.9	98.9	100.8		8.9			64.2	64.4	99.7	105.1
R2	6.0	6.2	96.8	90.9	26.4	26.2	100.8	100.0	10.1	10.1	100.0	105.2	59.0	59.2	99.7	96.6
U2(A)	5.2	4.7	110.6	78.8	27.0	27.4	98.5	102.3	9.0	9.0	100.0	93.8	56.1	53.6	104.7	91.8
V2	8.8	8.7	101.1	133.3	26.0	26.0	100.0	98.5	8.8	9.1	96.7	91.7	61.0	61.4	99.3	99.8
C3	7.2	7.2	101.4	110.6	26.2	26.2	100.0	99.2	8.6	9.4	91.5	89.6	59.0	61.5	95.9	96.6
D3(A)	5.8	5.8	100.0	87.9	26.7	26.6	100.4	101.1	10.5	10.0	105.0	109.4	60.7	61.0	99.5	99.3
E3(A)	6.2	6.1	101.6	93.9	26.6	26.6	100.0	100.8	9.8	8.9	101.1	93.8	61.0	62.3	97.9	99.8
T3	6.9	6.7	103.0	104.5	26.5	26.5	100.0	100.4	8.9	9.2	96.7	92.7	61.0	62.0	98.4	99.8
U3(A)	4.4	4.2	104.8	66.7	27.0	27.0	100.0	102.3	9.1	9.0	101.1	94.8	59.0	59.1	99.8	96.6
W3(A)	6.0	6.0	100.0	90.9	26.9	26.6	101.1	101.9	9.0	9.0	100.0	93.8	55.8	53.0	105.3	91.3
V3	6.3	6.4	98.4	95.4	26.1	26.2	99.6	98.9	8.9	8.9	100.0	92.7	65.0	67.0	97.0	106.4
J4	7.5	7.4	101.4	113.6	26.4	26.5	99.6	100.0	10.1	10.0	101.0	105.2	58.0	57.5	100.9	94.9
K4(A)	5.8	5.8	100.0	87.9	26.3	26.3	100.0	99.6	9.5	9.5	100.0	99.0	63.3	63.3	100.0	103.6
L4	5.4	5.5	91.5	81.8	26.4	26.0	101.5	100.0	9.4	9.6	97.9	97.9	60.1	61.4	97.9	98.4
M4	6.5	6.6	98.5	98.5	26.2	26.2	100.0	99.2	9.1	9.5	95.8	94.8	61.0	63.0	96.8	99.8
O4	7.2	7.1	101.4	109.1	26.3	26.3	100.0	99.6	10.7	10.8	99.1	111.4	59.0	59.8	100.0	97.9
Q4(A)	4.5	4.8	93.8	68.2	26.9	26.9	100.0	101.9	9.4	9.3	101.1	97.9	59.8	59.0	101.4	97.9
S4(A)	6.1	6.0	101.7	92.4	26.1	25.9	100.8	98.9	9.0	8.8	102.3	93.8	57.0	56.5	100.9	93.3
T4	7.1	6.9	102.9	107.6	26.3	26.3	100.0	99.6	8.7	8.7	100.0	90.6	68.0	68.2	99.7	111.3

FKBG DATA

	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED
CUR. AV	6.7	5.8	26.4	26.6	9.5	9.4	60.7	60.4
CUM. AV	6.6	5.8	26.4	26.6	9.6	9.4	61.1	60.2
IND. #D	101.5	100.0	100.0	100.0	99.0	100.0	99.3	100.3

(*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE II

AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM

NOVEMBER, 1985

	MOISTURE CONTENT, PERCENT				ADJ. BASIS WT.,*A LB./M SQ. FT.				CALIPER, PT.				CONCORA TEST LB.			
	MACHINE DATA				MACHINE DATA				MACHINE DATA				MACHINE DATA			
CODE *E	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C
A1	6.3	6.0	105.0	95.4	26.5	26.7	99.2	100.4					59.0	58.8	100.3	96.7
B1		6.8				26.1				7.9				70.0		
F1	7.3	7.6	96.0	110.6	26.0	26.0	100.0	98.5					60.0	60.2	99.7	98.4
J1	7.1	7.0	101.4	107.6	26.7	26.3	101.5	101.1	9.8	9.6	102.1	102.1	60.0	60.2	99.7	98.4
K1	7.2	7.3	98.6	109.1	26.7	26.3	101.5	101.1					62.0	61.4	101.0	101.6
L1	6.3	6.5	96.9	95.4	26.3	26.4	99.6	99.6	10.0	9.8	102.0	104.2	59.2	61.7	95.9	97.0
O1	7.5	7.5	100.0	113.6	26.4	26.5	99.6	100.0	10.3	10.2	101.0	107.3	57.0	58.1	98.1	93.4
S1(R)		7.2				26.3								61.7		
U1	5.0	6.8	102.3	136.4	25.8	25.8	100.0	97.7	10.3	10.6	97.2	107.3	62.4	61.3	101.8	102.3
A2	7.0	6.8	102.9	106.1	26.1	26.3	99.2	98.9					62.0	61.6	100.6	101.6
E2(R)	7.0	7.2	97.2	106.1	26.2	26.2	100.0	99.2	10.7	11.2	95.5	111.4	63.5	62.5	101.6	104.1
H2	7.1	7.0	101.4	107.6	25.9	26.2	98.8	98.1					61.0	60.6	100.7	100.0
I2	9.5	9.6	99.0	143.9	25.3	25.2	100.4	95.8	9.8	10.0	98.0	102.1	63.4	64.8	97.8	103.9
J2(R)	5.9	5.3	103.8	83.3	26.3	26.6	98.9	99.6	7.7	7.8	98.7	80.2	60.8	59.6	102.0	99.7
K2(R)	5.8	5.8	100.0	87.9	26.7	26.7	100.0	101.1	10.5	10.5	100.0	109.4	60.7	60.9	99.7	99.5
L2(R)	6.9	7.0	98.6	104.5	26.3	26.4	99.6	99.6	9.2	9.3	98.9	95.8	69.4	69.4	100.0	113.8
M2	6.6	6.6	100.0	100.0	26.9	26.9	100.0	101.9		8.9			63.7	64.3	99.1	104.4
R2	6.1	6.2	98.4	92.4	26.2	26.2	100.0	99.2	10.1	10.1	100.0	105.2	58.0	58.2	98.0	95.1
U2(R)	5.2	4.7	110.6	78.8	27.2	27.3	99.6	103.0	9.0	9.0	100.0	93.8	57.6	53.9	106.9	94.4
V2	8.8	8.7	101.1	133.3	25.9	26.0	99.6	98.1	9.4	9.1	103.3	97.9	61.0	61.4	99.3	100.0
C3	6.9	7.2	95.8	104.5	26.3	26.2	100.4	99.6	8.4	9.3	90.3	87.5	59.0	61.2	96.4	96.7
D3(R)	5.8	5.8	100.0	87.9	26.7	26.6	100.4	101.1	10.3	10.1	102.0	107.3	61.6	61.0	101.0	101.0
E3(R)	6.2	6.1	101.6	93.9	26.6	26.6	100.0	100.8	9.0	9.0	100.0	93.8	60.0	62.2	96.5	98.4
T3	6.8	6.7	101.5	103.0	26.5	26.5	100.0	100.4	9.0	9.2	97.8	93.8	62.0	61.9	100.2	101.6
U3(R)	4.3	4.2	102.4	65.2	27.0	27.0	100.0	102.3	9.6	9.0	106.7	100.0	59.1	59.0	100.2	96.9
M3(R)	6.0	6.0	100.0	90.9	26.9	26.6	101.1	101.9	9.0	9.0	100.0	93.8	55.4	53.3	103.9	90.8
Y3		6.4				26.2				8.9				66.6		
J4	7.5	7.5	100.0	113.6	26.4	26.5	99.6	100.0	10.0	10.0	100.0	104.2	57.0	57.5	99.1	93.4
K4(R)	5.8	5.8	100.0	87.9	26.3	26.3	100.0	99.6	9.5	9.5	100.0	99.0	63.7	63.3	100.6	104.4
L4	5.8	5.8	100.0	87.9	26.3	26.0	101.2	99.6	9.8	9.6	102.1	102.1	60.9	61.2	99.5	99.8
M4	6.5	6.6	98.5	98.5	26.2	26.2	100.0	99.2	9.0	9.4	95.7	93.8	64.0	62.8	101.9	104.9
O4	7.5	7.1	105.6	113.6	26.3	26.3	100.0	99.6	10.4	10.7	97.2	108.3	59.3	59.8	99.2	97.2
Q4(R)	4.4	4.8	91.7	66.7	27.0	26.9	100.4	102.3	9.7	9.4	103.2	101.0	59.1	59.2	99.8	96.9
S4(R)	6.1	6.0	101.7	92.4	26.0	25.9	100.4	98.5	8.6	8.8	97.7	89.6	58.0	56.5	102.6	95.1
T4	7.0	7.0	100.0	106.1	26.3	26.3	100.0	99.6	9.0	8.7	103.4	93.8	68.0	68.2	99.7	111.5

FKBG DATA	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED
CUR. AV	6.6	5.8	26.4	26.6	9.5	9.4	60.9	60.7
CUM. AV	6.6	5.8	26.4	26.6	9.6	9.4	61.0	60.2
IND. *D	100.0	100.0	100.0	100.0	99.0	100.0	99.8	100.8

(*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE III

AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM

DECEMBER, 1985

CODE	MOISTURE CONTENT, PERCENT				ADJ. BASIS WT., #/M SQ. FT.				CALIPER, PT.				CONCORA TEST LB.			
	MACHINE DATA				MACHINE DATA				MACHINE DATA				MACHINE DATA			
	CUR. AV.	CUM. AV.	FACT. #B	IND. #C	CUR. AV.	CUM. AV.	FACT. #B	IND. #C	CUR. AV.	CUM. AV.	FACT. #B	IND. #C	CUR. AV.	CUM. AV.	FACT. #B	IND. #C
A1	6.1	6.0	101.7	92.4	26.5	26.7	99.2	100.4					59.0	58.9	100.2	96.7
B1		6.2				26.1				7.9				70.0		
F1	7.2	7.6	94.7	109.1	26.0	26.0	100.0	98.5					60.0	60.3	99.5	98.4
J1	7.4	7.0	105.7	112.1	26.3	26.4	99.6	99.6	9.6	9.6	100.0	101.0	59.0	60.3	97.8	96.7
M1	7.1	7.4	95.9	107.6	26.3	26.3	100.0	99.6					60.0	61.3	97.9	98.4
L1	5.9	6.5	90.8	89.4	26.3	26.4	99.6	99.6	9.7	9.8	99.0	102.1	59.7	61.5	97.1	97.9
Q1	7.4	7.5	98.7	112.1	26.5	26.5	100.0	100.4	10.2	10.2	100.0	107.4	57.0	58.0	98.3	93.4
S1(A)		7.2				26.3								61.7		
U1	8.3	8.8	94.3	125.8	25.9	25.8	100.4	98.1	10.2	10.6	96.2	107.4	64.6	61.4	105.2	105.9
A2	7.8	8.8	102.9	106.1	26.1	26.3	99.2	98.9					63.0	61.6	102.3	103.3
E2(A)	7.8	7.2	97.2	106.1	26.1	26.2	99.6	98.9	10.9	11.1	98.2	114.7	63.5	62.7	101.3	104.1
H2	7.1	7.0	101.4	107.6	26.1	26.2	99.6	98.9					60.0	60.8	98.7	98.4
I2	9.7	9.6	101.8	147.8	25.3	25.2	100.4	95.8	9.8	10.0	98.8	103.2	63.8	64.7	98.6	104.6
J2(A)	5.4	5.3	101.9	81.8	26.4	26.6	99.2	100.6	7.7	7.8	98.7	81.0	61.4	59.7	102.8	100.6
M2(A)	5.8	5.8	100.6	87.9	26.7	26.7	100.0	101.1	10.4	10.5	99.0	109.5	60.9	61.0	99.8	99.8
L2(A)	6.2	7.0	97.1	103.8	26.3	26.4	99.6	99.6	9.2	9.2	100.0	96.8	69.3	69.4	99.8	113.6
N2	6.6	6.6	100.8	100.0	26.9	26.9	100.0	101.9		9.8			62.7	64.2	97.7	102.8
R2	5.8	6.2	93.5	87.9	26.3	26.2	100.4	99.6	10.8	10.1	99.0	105.3	59.0	59.1	99.8	96.7
U2(A)	5.2	4.8	102.3	78.8	27.0	27.3	98.9	102.3	9.6	9.8	100.0	94.7	56.8	54.4	104.4	93.1
V2	8.8	8.7	101.1	133.3	26.8	26.8	100.8	98.5	9.4	9.2	102.2	98.9	61.8	61.4	99.3	100.8
C3	6.6	7.2	91.7	100.8	26.2	26.2	100.8	99.2	8.3	9.1	91.2	87.4	58.8	61.8	95.1	95.1
D3(A)	5.8	5.8	100.6	87.9	26.7	26.6	100.4	101.1	10.4	10.2	102.8	109.5	60.9	61.1	99.7	99.8
E3(A)	6.3	6.1	102.2	95.4	26.5	26.6	99.6	100.4	8.9	9.8	98.9	93.7	60.8	62.8	96.8	98.4
V3	6.8	6.7	101.5	103.8	26.5	26.5	100.8	100.4	9.1	9.1	100.8	95.8	61.8	62.8	98.4	100.8
U3(A)	4.4	4.2	104.8	66.7	27.8	27.8	100.8	102.3	9.1	9.1	100.8	95.8	59.6	59.1	100.8	97.7
D3(A)	6.6	6.8	100.8	98.9	26.9	26.7	100.7	101.9	9.8	9.8	100.8	98.7	57.8	53.6	107.8	98.8
V3		6.4				26.2				9.8				66.3		
J4	7.5	7.5	100.8	113.6	26.4	26.5	99.6	100.8	10.1	10.8	101.8	106.3	57.8	57.5	99.1	93.4
M4(A)	5.5	5.8	101.7	89.4	26.2	26.3	99.6	99.2	9.5	9.5	100.8	100.8	64.2	63.3	101.4	105.2
L4	6.2	5.8	106.9	93.9	26.1	26.1	100.8	98.9	9.7	9.6	101.8	102.1	61.4	61.1	100.5	100.6
N4	6.6	6.6	100.8	100.8	26.2	26.2	100.8	99.2	9.1	9.4	96.8	95.8	64.8	62.8	101.9	104.9
Q4	7.4	7.2	102.8	112.1	26.5	26.3	100.8	100.4	10.5	10.7	98.1	110.5	59.9	59.8	100.2	98.2
S4(A)	4.6	4.8	95.8	69.7	26.9	26.8	100.4	101.9	9.3	9.4	98.9	97.9	59.9	59.2	101.2	98.2
T4	6.5	6.6	100.1	98.5	26.1	25.9	100.8	98.9	8.5	8.8	96.6	89.5	57.8	56.7	100.5	93.4
V4	6.9	7.8	98.6	104.5	26.5	26.3	100.8	100.4	9.1	8.7	104.6	95.8	66.8	68.2	96.8	108.2

FKBG DATA

	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED
CUR. AV	6.6	5.8	26.4	26.6	9.5	9.3	60.8	60.9
CUM. AV	6.6	5.8	26.4	26.6	9.5	9.4	61.0	60.3
IND. #D	100.0	100.0	100.0	100.0	100.0	98.9	99.7	101.0

(*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE IV

AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM

RING COMPRESSION, LBS.

	OCTOBER, 1985				NOVEMBER, 1985				DECEMBER, 1985			
	MACHINE DATA				MACHINE DATA				MACHINE DATA			
	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C
A1	31.0	32.5	99.4	97.2	29.0	32.4	89.5	90.9	37.0	32.0	115.6	116.4
B1												
F1	30.0	28.3	106.6	94.0	29.0	28.3	102.5	90.9	28.0	28.3	98.9	88.0
J1	29.0	30.7	94.5	90.9	28.0	30.2	92.7	87.8	29.0	29.8	97.3	91.2
K1	31.0	30.0	103.3	97.2	30.0	30.2	99.3	94.0	29.0	30.2	96.0	91.2
L1												
O1	29.0	30.0	96.7	90.9	29.0	29.9	97.0	90.9	30.0	29.8	100.7	94.3
S1(R)												
U1	34.6	35.9	96.4	108.5	36.2	35.6	101.7	113.5	30.9	35.6	86.8	97.2
A2	26.0	30.2	86.1	81.5	25.0	29.8	83.9	78.4	27.0	29.5	91.5	84.9
E2(R)	28.0	29.6	94.6	87.8	30.0	29.6	101.4	94.0	30.0	29.8	100.7	94.3
H2	24.8	24.6	97.6	75.2	25.0	24.5	102.0	78.4	24.0	24.5	98.0	75.5
I2	28.1	29.1	96.6	88.1	29.3	28.7	102.1	91.8	28.7	28.5	100.7	90.2
J2(R)	29.0	29.4	98.6	90.9	28.8	29.4	98.0	90.3	29.2	29.3	99.6	91.8
K2(R)												
L2(R)												
M2	32.0	29.8	107.4	100.3	32.0	30.2	106.0	100.3	31.0	30.4	102.0	97.5
R2		31.1				31.1				30.8		
U2(R)		25.8				25.8				25.8		
Y2	42.0	38.9	108.0	131.7	41.0	39.3	104.3	128.5	42.0	39.8	105.5	132.1
C3	41.0	41.1	99.8	128.5	42.0	41.1	102.2	131.7	41.0	41.4	99.0	128.9
D3(R)												
E3(R)	37.0	38.4	96.4	116.0	39.0	38.2	102.1	122.2	37.8	38.2	96.8	116.4
T3	32.0	34.1	93.8	100.3	31.0	33.8	91.7	97.2	31.0	33.5	92.5	97.5
U3(R)	26.1	25.5	100.8	81.8	23.7	25.8	91.9	74.3	24.9	25.5	97.6	78.3
W3(R)		25.4				25.4				25.4		
Y3												
J4	27.0	28.0	96.4	84.6	28.0	27.9	100.4	87.8	28.0	28.0	100.0	88.0
K4(R)	32.0	31.0	103.2	100.3	33.3	31.3	106.4	104.4	34.0	31.6	107.6	106.9
L4	33.8	33.4	101.2	106.0	31.4	33.4	94.0	98.4	30.1	33.4	90.1	94.6
M4		32.6				32.7				32.6		
O4	39.7	38.0	104.5	124.4	39.4	38.5	102.3	123.5	38.7	38.8	99.7	121.7
Q4(R)	26.0	25.6	101.6	81.5	24.4	25.7	94.9	76.5	24.6	25.5	96.5	77.4
S4(R)	44.0	41.2	106.8	137.9	39.0	41.4	94.2	122.2	38.0	41.2	92.2	119.5
T4												

FKBG DATA

	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED
CUR. AV	31.8	31.7	31.4	31.2	31.4	31.1
CUM. AV	31.9	31.0	31.9	31.0	31.8	31.1
IND. *D	99.7	102.2	98.4	100.6	98.7	100.0

(*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE V

DATA ON CONDITIONING AND TESTING ENVIRONMENTS

OCTOBER, NOVEMBER, DECEMBER, 1985

	Conditioning Environment				Testing Environment
	Are Quality Samples	Procedure			Are Quality Samples Tested Under Controlled Conditions
Code	Conditioned Before Testing?	Time	Temp., °F	RH, %	of Temperature & Humidity?
A1	No	--	--		Yes: 70 ± 5°F; 55 ± 5% RH
B1	No data was submitted for this period				
F1	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
J1	No	--	--	--	No
K1	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
L1	No	--	--	--	Yes: 72 ± 2°F; 50 ± 2% RH
O1	No	--	--	--	Yes: 72 ± 2°F; 50 ± 2% RH
S1	No data was submitted for this period				
U1	No	--	--	--	Yes: 72 ± 3°F; 50 ± 2% RH
A2	No	--	--	--	Yes: 70 ± 5°F; 55 ± 5% RH
E2	Yes	--	--	--	Yes: 70 ± 2°F; 50 ± 2% RH
H2	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
I2	No	--	--		Yes: 72 ± 2°F; 50 ± 2% RH
J2	No	--	--	--	Yes: 75 ± 2°F; 50 ± 5% RH
K2	No	--	--	--	Yes: 72 ± 4°F; 50 ± 5% RH
L2	No	--	--	--	Yes: 72 ± 1°F; 50 ± 1% RH
M2	No	--	--	--	No
R2	No	--	--	--	No
U2	No	--	--	--	Yes: 73 ± 3°F; 50 ± 2% RH
Y2	No	--	--	--	Yes: 70 ± 2°F; 50 ± 10% RH
C3	No	--	--	--	Yes: 72 ± 2°F; 50 ± 1% RH
D3	No	--	--	--	Yes: 72 ± 4°F; 50 ± 5% RH
E3	No	--	--	--	No
T3	No	--	--	--	No
U3	No	--	--	--	No
W3	No	--	--	--	Yes: 73 ± 3°F; 50 ± 2% RH
Y3	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
J4	No	--	--	--	Yes: 72 ± 2°F; 50 ± 2% RH
K4	No	--	--	--	Yes: 72 ± 2°F; 50 ± 3% RH
L4	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
M4	No	--	--	--	Yes: 73°F; 50% RH
O4	No	--	--	--	Yes: 70 ± 2°F; 50 ± 2% RH
Q4	No	--	--	--	No
S4	Yes	15 min	--	--	Yes: 72 ± 3.5°F; 50 ± 2% RH
T4	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH

THE INSTITUTE OF PAPER CHEMISTRY

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APPENDIX

NOTES A, B, C, D, AND E, USED IN TABULATIONS OF MILL DATA

Notes A, B, C, D, and E, used in the tables of mill data are given below; these notes define the procedure used in calculating adjusted basis weight, machine factor, machine index, and F.K.B.G. index. It should be stressed that each formula is applicable only to a specific physical property of corrugating medium.

Note A: Adjusted basis weight (ABW) = reported weight (RBW) adjusted to moisture content of 7.8%:

$$\text{ABW} = \text{RBW}\left[\frac{(100 - \text{reported moisture content, \%})}{(100 - 7.8)}\right]$$

Note B: Machine factor (%) $= \left[\frac{\text{Current machine average}}{\text{Cumulative machine average}}\right] \cdot 100$ where

$$\text{Cumulative machine average} = \frac{\text{CMA's}^{a} \text{ for previous 12 months excluding CMA for current month}}{12}$$

Note C: Machine index (%) $= \left[\frac{\text{Current machine average}}{\text{Cumulative F.K.B.G. total average}}\right] \cdot 100$ where

$$\text{Cumulative F.K.B.G. average} = \frac{\text{CFKBGA's}^{b} \text{ for previous 12 months excluding CFKBGA for current month}}{12}$$

Note D: F.K.B.G. index (%) $= \left[\frac{\text{Current F.K.B.G. average}}{\text{Cumulative F.K.B.G. average}}\right] \cdot 100$ where

$$\text{Current F.K.B.G. average} = \frac{\text{CMA's}^{a} \text{ for current month for all machines}}{\text{Number of machines}}$$

Note E: (R) - Indicates a medium manufactured from recylced fibers.

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[a]CMA = current machine average for a specific physical property of 26-lb corrugating medium obtained during a given month on a specific machine.

[b]CFKBGA = current F.K.B.G. average for a specific physical property of 26-lb corrugating medium obtained during a given month.

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Continuous Base-Line Study
(Modified) (Mill Corrugating
Medium Data for October,
November, December, 1985).

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